

79,375

Dart Aerospace Ltd.

Date: Wednesday, 02/04/2008 3:39:05 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY LOCK CASHING
Job Number	: 38333		
Estimate Number	: 10474		
P.O. Number	:	Part Number	: D33931
This Issue	: 02/04/2008	Drawing Number	: D3393 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 37149	Material	:
Written By	:	Due Date	: 30/04/2008
Checked & Approved By	: <u>JO 08.4.05</u>	Qty:	10
Comment	: Est. A 05.02.18 New issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
Comment: Qty.: 0.2843 f(s)/Unit Total : 2.8434 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.500) Batch: <u>M107244</u> <u>SA 08/04/15</u> (10)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank: 1.500" x 1.500" x 3.125" long Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1 Deburr <u>SL/SA 08/04/15</u> (10)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SL 08/06/01</u> (10)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SL/SA 08.06.01</u> (10)		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SL/SL 08/06/05</u> (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D33931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 180 S2



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M-1

30 min
09/06/2008
S.300 12.09
#1 320/5 F
#2 B38333 F
#3 D33931 F
#4 D33931 F

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Feb 08/06/09 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 481

AS 08/06/09 XIC

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



Lu 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

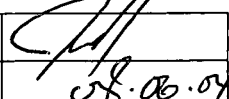
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	38333
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
* Ø0.750	+/-0.010	.750	✓			
* 0.625	+/-0.010	.625	✓			
Ø1.250	+/-0.010	1.249	✓			
1.088	+/-0.010	1.088	✓			
Ø0.734	+/-0.010	.737	✓			
2.658	+/-0.010	2.657	✓			
1.550	+/-0.010	1.551	✓			
* 0.125 x 45°	+/-0.010	125x45°	✓			
1.50	+/-0.030	1.490	✓			
0.750	+/-0.010	.749	✓			
Ø1.050	+/-0.010	1.053	✓			
Ø1.000	+/-0.010	.999	✓			
0.338	+/-0.010	.340	✓			
0.563	+/-0.010	.573	✓			
0.100	+0.000/-0.010	.096	✓			
3.00	+/-0.030	3.002	✓			
1.500	+/-0.010	1.502	✓			
0.375	+/-0.010	.375	✓			
1.25	+/-0.030	1.250	✓			
0.125	+/-0.010	.120	✓			
30°	0.5°	30°	✓			

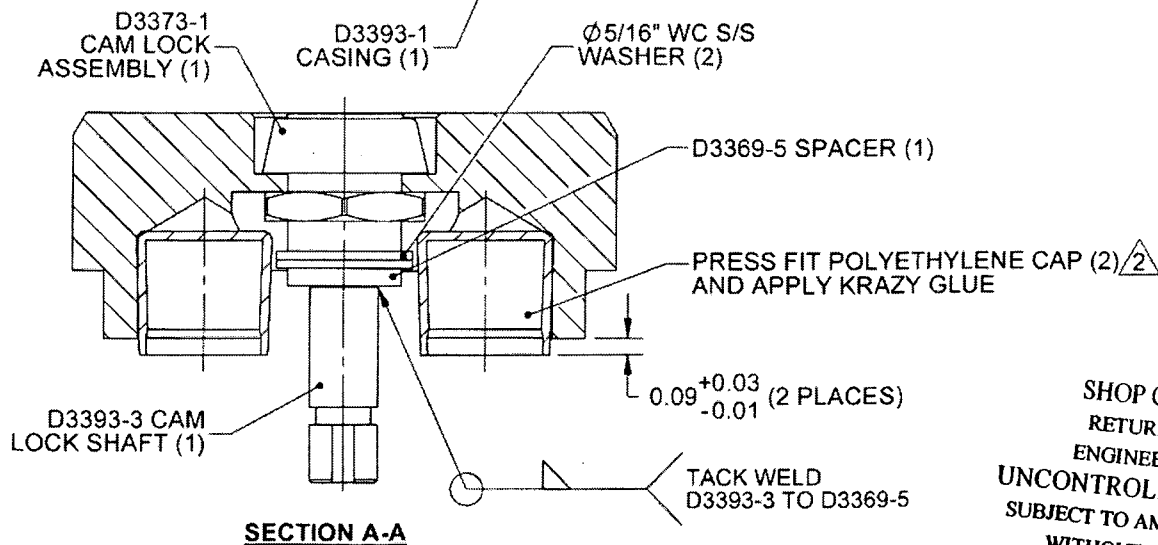
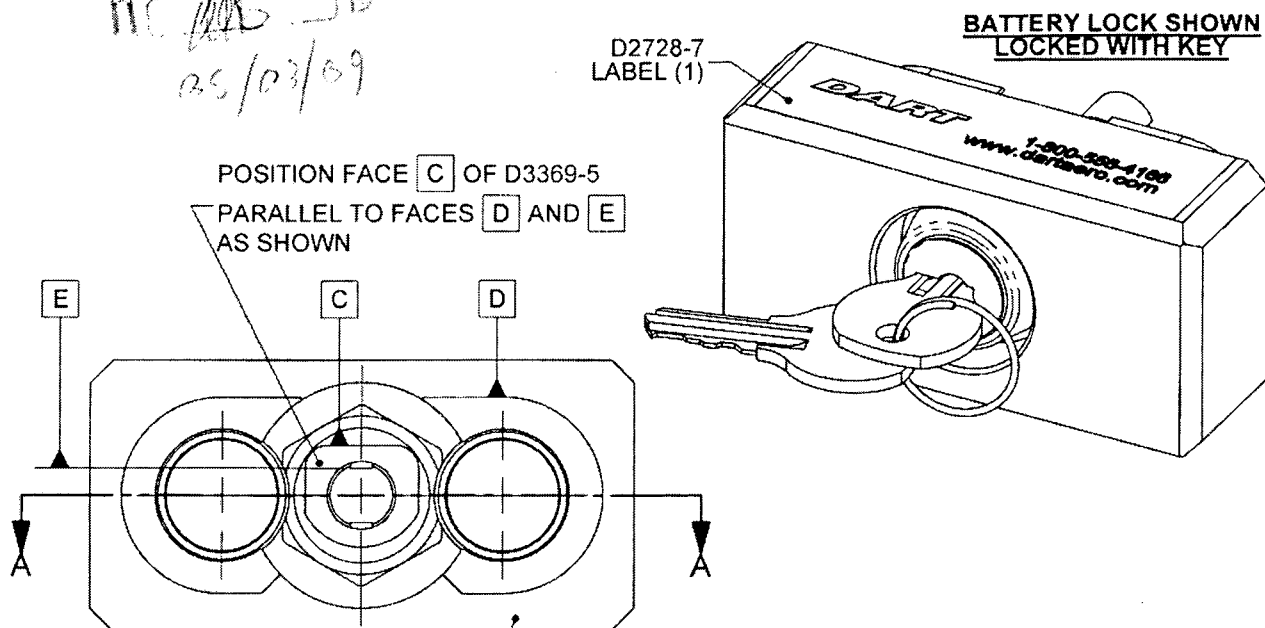
Measured by:	3L	Audited by:		Prototype Approval:	N/A
Date:	02/06/02	Date:	28.06.02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM 	



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
RC [Signature]
05/03/09



D3393-041 BATTERY LOCK ASSEMBLY

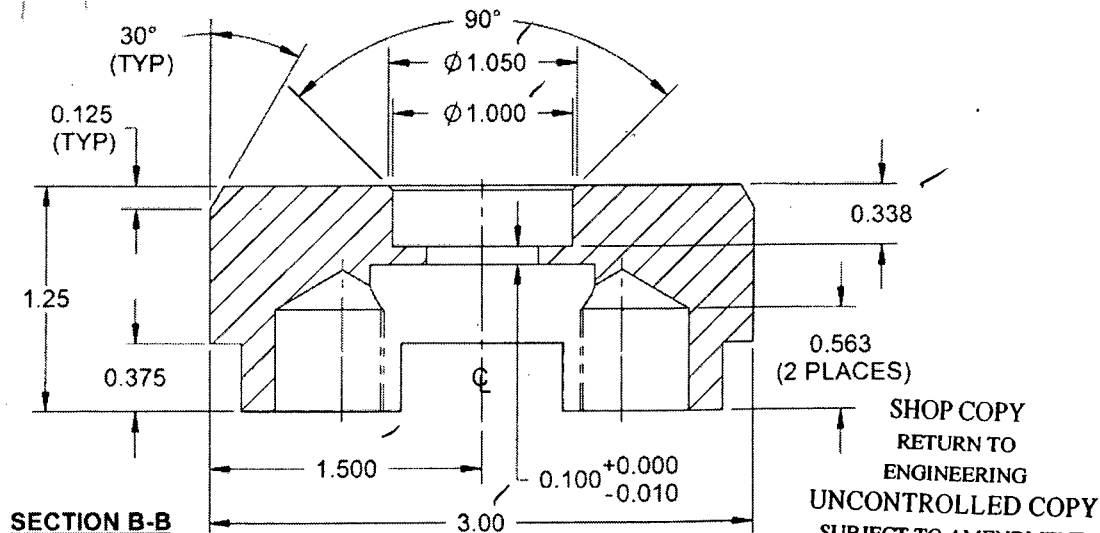
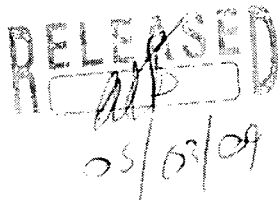
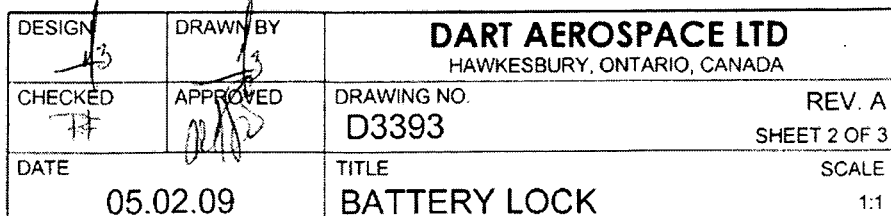
NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

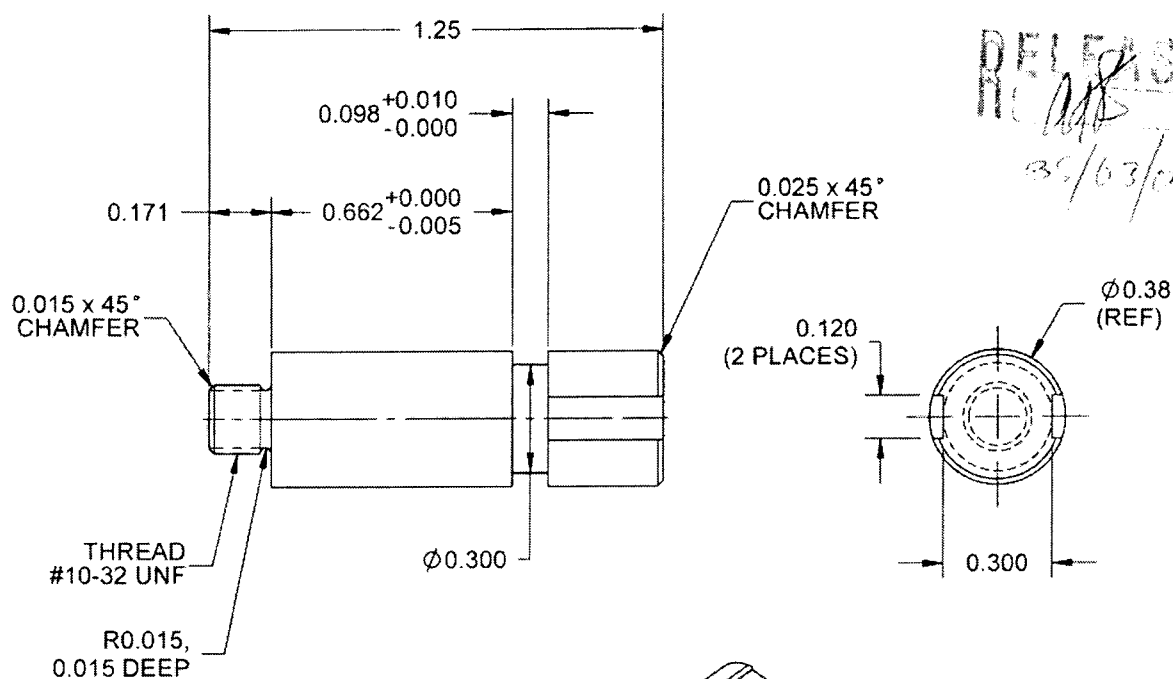
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DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 74	APPROVED 213	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



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D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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